

Date: Wednesday, 7/5/2006 2:44:16 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350/355 AS X-TUBE AFT
Job Number : 27829	
Estimate Number : 12486	
P.O. Number : <i>N/A</i>	Part Number : D350748201
This Issue : 7/5/2006	Drawing Number : IIN D350-748 P5 PREL <i>06-07-05</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i>	Drawing Revision : PREL
Previous Run : 27828	Material : <i>N/A</i>
Written By : _____	Due Date : 7/30/2006
Checked & Approved By : _____	Qty: 1 Um: Each
Comment : Est Rev:A New Issue 06-07-05 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD350-748-201

CHG001

2.0	27829A	X-TUBE AS 350/355 HI AFT
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Comment: Sub-Component X-TUBE AS 350/355 HI AFT

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

4.0	D35001	350 SADDLE
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
 350 SADDLE
 Batch: *B28477*

5.0	D35011	BUSHING
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Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)
 BUSHING
 Batch: *B27799*

6.0	AN46A	Bolt
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Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)
 Bolt
 Batch: *4102962*

7/3/11 SB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Job Number: 27829

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Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

AN441A

bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

bolt

Batch: M102552 ✓

8.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M103481 ✓

9.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total: 32.0000 Each(s)

Washer

Batch: M1041215 ✓

10.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

Batch: M103694 ✓

11.0

MS21042L4

Nut



Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)

Nut

Batch: M102552 ✓

12.0

MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Nut

Batch: M103830 ✓

7/7/12 SP

13.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

6/7/12 (1)

6/27/12 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/12

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 27829

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-201

Location: _____

PPP Rev: A

10/12/12

(1)

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

10/10/12

Job Completion



U 070712

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

3.10 Apply a continuous bead of Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class B2 sealant in the following locations as per Figure 6:

- A) Along saddle/crosstube interface.
- B) Between the saddle flanges.
- C) Along saddle/skidtube interface.

4.0 WEIGHT AND BALANCE

The following weight and balance information is for Dart crosstube installations only. This data should be similar to the existing installation. Differences from the parts removed are the responsibility of the installer.

DART CROSSTUBE	FWD/AFT	WEIGHT	STA	MOMENT
D350-748-101	Fwd	35.2 lb (16.0 kg)	106.3 in (2.70 m)	3742 lb-in (43.2 kg-m)
D350-748-201	Aft	34.7 lb (15.7 kg)	162.4 in (4.12 m)	5635 lb-in (64.7 kg-m)

5.0 PARTS LIST

Qty -101	Qty -201	Part Number	Description
X		D350-748-101	CROSSTUBE INSTALLATION, AS 350/355 HIGH FWD
	X	D350-748-201	CROSSTUBE INSTALLATION, AS 350/355 HIGH AFT
1		D350-748-141	CROSSTUBE ASSEMBLY, AS 350/355 HIGH FWD
	1	D350-748-241	CROSSTUBE ASSEMBLY, AS 350/355 HIGH AFT
*2	*2	D3502-1	SUPPORT
*2	*2	D2856-400-710	ABRASION STRIP
*1	*1	AELS-1032-225	INSERT
*2	*2	MS21920-20	CLAMP
*1	*1	MS27039-1-10	SCREW
*1	*1	AN960JD10	WASHER
4	4	D3500-1	SADDLE
16	16	D3501-1	BUSHING
16	16	AN4-6A	BOLT
8	8	AN4-41A	BOLT
4	4	AN5-32A	BOLT
32	32	AN960JD416	WASHER
8	8	AN960JD516	WASHER
24	24	MS21042L4	NUT (OR MS21042-4)
4	4	MS21042L5	NUT (OR MS21042-5)

* REFERENCE ONLY. PARTS ARE INCLUDED IN D350-748-141/241 ASSEMBLIES ABOVE

STOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 22829

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Revision: A

Date: 06.05.08